

Work Order ID 147066

Tuesday, May 31, 2016 10:54:48 AM

147066

Page 1

Item ID: D3456-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Washer
 Start Date: 6/3/2016 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date **MAY 31 2016** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3456	Rev A								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>32575</u> P/N: 91525A120 per Dwg D3456Possible Supplier: McMaster-CarrMaterial release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.08							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

25 JUN 02 2016 DAS 13 9-89

25x 8016-6-6.

(25) DAS 38 9-89 JUN 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Work Order ID 147066

Tuesday, May 31, 2016 10:54:49 AM

147066

Page 2

Item ID: D3456-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Washer

Stop ***NS2***

Start Date: 6/3/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>705A</u>	0.00							
130									
Packaging	Memo	0.04							DAS 6 3-28
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.42							
Quality Control									

MCS JUN 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Tuesday, May 31, 2016 10:54:52 AM

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147066

D3456-1

Required Date: 6/17/2016

Required Qty: 25.00

Comments: IPP A05.10.03New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
91525A120		Purchased	No			100	Each	0.0000	1	25			
91525A120 washer									**	25		8/16-6-6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

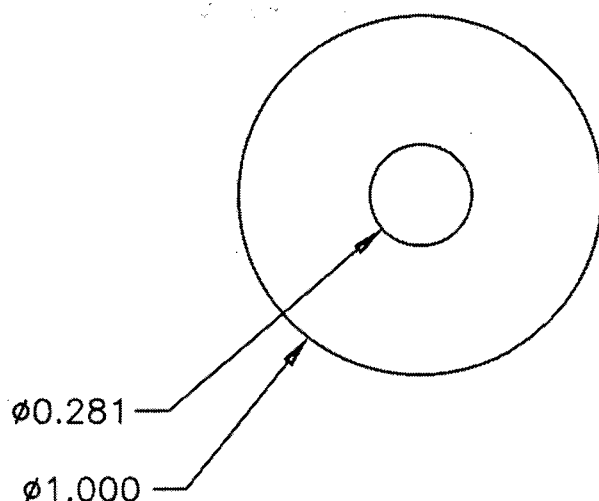
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3456	REV. A SHEET 1 OF 1
DATE 05.09.01		TITLE WASHER	SCALE 2:1
A	05.09.01	NEW ISSUE	

RELEASED
05.09.06

SPECIFICATION CONTROL DRAWING



D3456-1 WASHER

- 1) MATERIAL: 316 STAINLESS STEEL, 0.050" THICK
- 2) MAY PURCHASE McMASTER-CARR P/N 91525A120
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142066 NCS
1605-21

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32575

Purchase Order Date 6/2/2016

PO Print Date 6/2/2016

Page Number 1 of 6

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

~~JUN 02 2016~~

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	USD
Ship Via:	Purolator ground ppd	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	3408A59	BALL PLUNGER	6/6/2016 Yes 6/6/2016		4.00 Each	\$7.98	\$31.92
Line Total:							\$31.92
2	D3373-1P	Cam Lock	6/6/2016 Yes 6/6/2016		20.00 Each	\$6.32	\$126.40
Line Total:							\$126.40
3	91525A120 ✓	washer	6/6/2016 Yes 6/6/2016		25.00 Each ✓	\$0.27	\$6.66

AS PER DWG D3456 REV. A
B147066

Note:

6/2/2016

Spoke-b-b

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Ian
Chantal

Purchase Order
PO32575
Order Placed By
Chantal Lavoie
McMaster-Carr Number
4106070-01

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06/02/2016

Line	Product	Ordered	Shipped
1	3408A59 Ball-Nose Spring Plunger with Stainless Steel Ball, Stainless Steel Body, with Element, 5/8"-11 Thread, 7-50 lb Nose Force	4 Each	4
2	1770A525 Cam Lock with Polished Nickel Finish, Keyed to C420A, 3/4" Diameter Hole, 7/64" Material Thickness	20 Each	20
3	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	1 Pack	1 <i>Sp/6 to 6.</i>
4	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD., White, Packs of 50	1 Pack	1
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100, We Shipped 1 Pack To Meet Your Need For 50 Each	1 Pack	1
6	93695K58 Oil-Rst Fire-Retardant Blended Buna-N Foam, 50 ft. Adhesive-Back Strip, 1/4" Thickness, 1" WD	1 Each	1
7	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	15 Each	15
8	8612K61 ✓ Fabric-Reinforced Silicone Rubber Sheet, HT-Temperature, 24" X 36", 1/16" Thickness	6 Each	6 ✓
9	7014A11 ✓ Easy I. D. Socket Holder, for 1/4" Square Drive, 1/8" - 5/8" Socket Size	1 Each	1 ✓
10	7014A12 ✓ Easy I. D. Socket Holder, for 3/8" Square Drive, 1/4" - 1" Socket Size	1 Each	1 ✓
11	7014A13 ✓ Easy I. D. Socket Holder, for 1/2" Square Drive, 3/8" - 1-1/4" Socket Size	1 Each	1 ✓
12	7014A21 ✓ Easy I. D. Socket Holder, for 1/4" Square Drive, 4MM - 15MM Socket Size	1 Each	1 ✓
13	7014A22 ✓ Easy I. D. Socket Holder, for 3/8" Square Drive, 6MM - 20MM Socket Size	1 Each	1 ✓
14	7014A23 ✓ Easy I. D. Socket Holder, for 1/2" Square Drive, 10MM - 27MM Socket Size	1 Each	1 ✓
15	90177A216 Zinc-Plated Steel Split Ring, 3/4" OD, 5/8" ID, Packs of 50	1 Pack	1

C216106103

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 63090584
Purchase Order: PO32575
Release:
McMaster-Carr Number: 4106070-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 02-Jun-2016
Shipper's Export Declaration (SED):
NO EEI 30.36
FOB: ORIGIN

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping Ian
Attention: Chantal
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	3408A59 Ball-Nose Spring Plunger with Stainless Steel Ball, Stainless Steel Body, with Element, 5/8"-11 Thread, 7-50 lb Nose Force Country of Origin: United States Schedule B #: 732690 ECCN #: EAR99 NLR	4 EA	\$7.98	\$31.92
2	1770A525 Cam Lock with Polished Nickel Finish, Keyed to C420A, 3/4" Diameter Hole, 7/64" Material Thickness Country of Origin: United States Schedule B #: 830130 ECCN #: EAR99 NLR	20 EA	\$6.32	\$126.40
3	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	1 PK	\$6.26	\$6.26
4	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD., White, Packs of 50 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.12	\$8.12

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 14

Number of Packages: 1

Invoice Amounts:

Merchandise Amount:
Total (In USD):

\$1,009.61
\$1,009.61

Package Dimensions:

64 X 33 X 34 CM = .071 CUBIC M

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Remit payment to:

(by wire transfer)

Bank of America

(by mail)

McMaster-Carr Supply Company
PO Box 7690
Chicago, IL 60680-7690 USA

222 Broadway

New York, NY 10038

Account 86666-02021

SWIFT BOFAUS3N

Authorized Signature:

Date:

02-Jun-2016

Name: Sarah Weinberg

Title: Operations Mgr.

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